

Ship 24/10 1111

Dart Aerospace Ltd.

Date: Tuesday, 10/17/2006 10:58:22 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOOR WINDOW
Job Number : 29031
Estimate Number : 10457
P.O. Number : N/A Part Number : D32121
This Issue : 10/17/2006 S.O. No. : N/A Drawing Number : D3212 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B
Previous Run : 26931 Material : ~~Multiples of 4~~
Written By : Due Date : 10/24/2006 Qty: 10 Um: Each
Checked & Approved By : 06 10 16
Comment : Est Rev: A New Issue 05-11-09 JLM
Est Rev: B Water jet/ ecn798 06-05-08 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MACRLICS125 1/8" Polycast II Sheet



Comment: Qty.: 1.0232 sf(s)/Unit Total : 10.2323 sf(s)
Material: 0.125" Polycast Sheet
(M-ACRYLIC-S.125)
Identify as D3212-1
Batch: 117626

06 10 17

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3212
Dwg Rev: B
Prog Rev: B

06 10 17

10

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06 10 18

10

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06 10 20

5.0 D27281 Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Qty Part # Description Batch
1 D2728-1 Dart Logo label B24215

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 04/2/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/17/2006 10:58:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 29031

Part Number: D32121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary

2-Polish windows as necessary to remove any imperfections using Davos 1, 2, 3 pol
3-Install label as per Dwg D3212

06/12/06

06/10/25

(P70)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1-Wrap in plastic wrap after inspection

06/12/08 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5784

06/12/08 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/08 (10)

Job Completion



06/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-10-25	6.0	Add Polish windows AS shown. Perm. Change <i>[Signature]</i>					<i>[Signature]</i> 06-10-25

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29031
Description: Floor Window		Part Number:	D3212-1
Inspection Dwg: D3212	Rev: KB <i>11</i>		Page 1 of 1

06.10.17

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.734	✓		Measuring tape	
6.367	+/-0.005	6.366	✓		vern	
0.625	+/-0.005	0.625	✓		vern	
Ø 0.156	+0.005/-0.000	0.160	✓		vern	
R0.25	+/-0.030	R0.25	✓		Radius Gauge	
8.150	+/-0.005	8.148	✓		vern	
3.750	+/-0.005	3.748	✓		vern	
0.313	+/-0.010	0.312	✓		vern	
15.14	+/-0.030	15.13	✓		measuring tape	
12.520	+/-0.005	12.515	✓		vern	
6.260	+/-0.005	6.257	✓		vern	
1.312	+/-0.005	1.312	✓		vern	
0.313	+/-0.010	0.313	✓		vern	
3.750	+/-0.005	3.749	✓		vern	
8.150	+/-0.005	8.149	✓		vern	
8.462	+/-0.005	8.460	✓		vern	
9.09	+/-0.030	9.08	✓		vern	



Measured by:	<i>M. M.</i>
Date:	06.10.18

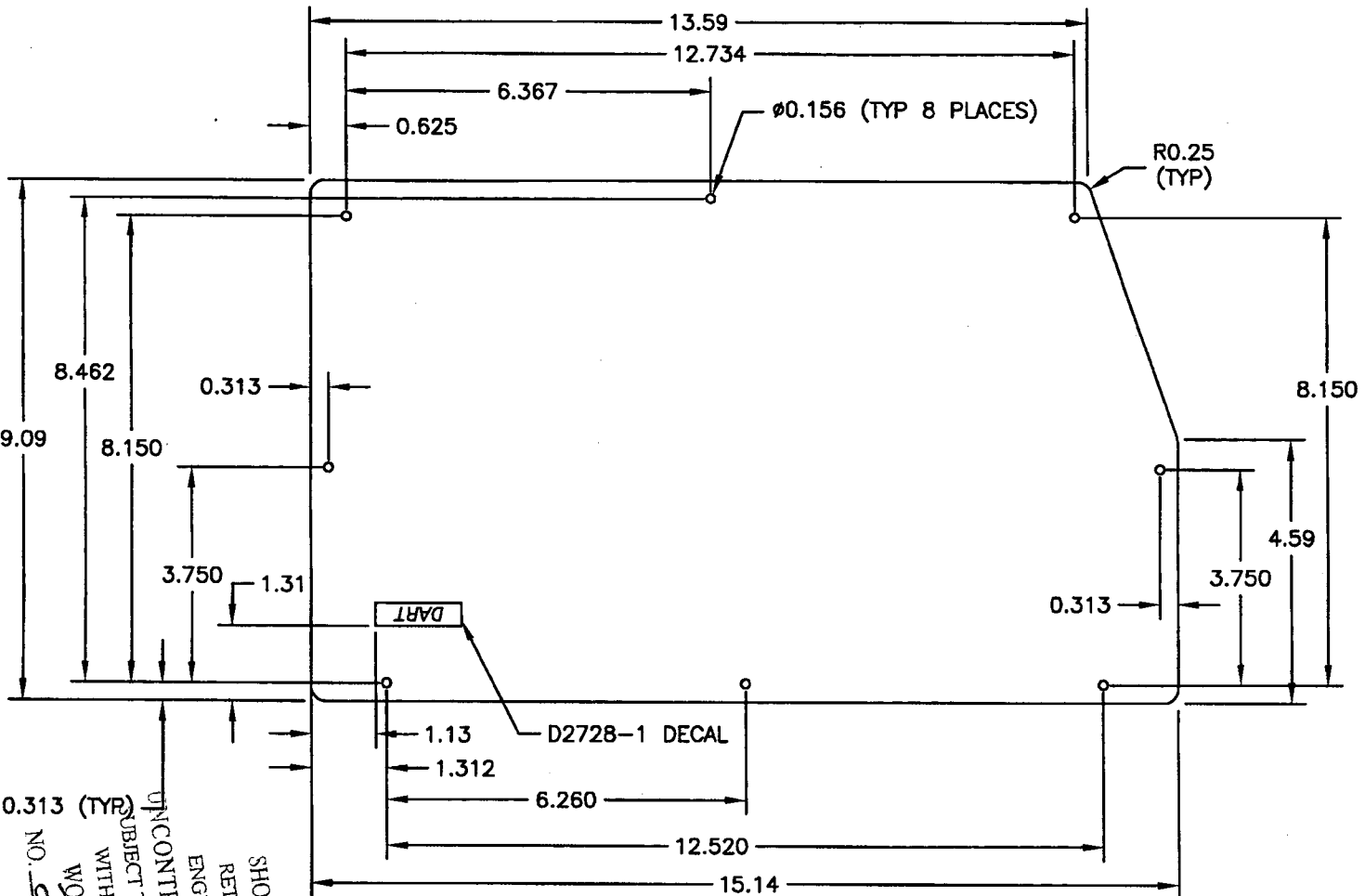
Audited by:	<i>[Signature]</i>
Date:	06.10.20

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue	P/O D350-567-015/-025/-031 KJ/RF <i>[Signature]</i>	<i>[Signature]</i>


DART

DESIGN	CP	DRAWN BY	SSH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. B
CHECKED		APPROVED		DRAWING NO.	D3212	SHEET 1 OF 1
DATE	06.04.13			TITLE	FLOOR WINDOW	SCALE 1:3



D3212-1 FLOOR WINDOW

- 1) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1
- 2) DIMENSIONS ARE IN INCHES AND ARE FOR REFERENCE ONLY
- 3) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dec. 01. 20 

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